

Work Order ID 81143

March-09-12 1:09:22 PM

81143

Page 1

Item ID: D4018-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib
 Start Date: 09/03/2012 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 16/03/2012 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/09 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4018 | C |

100 0.00
100
 Large Fab Memo 0.00
 Large Fab 1- Cut tube as per dwg D4018
 2- debur and remove identification markings

SAP 12-03-26 (2)

110 QC6- Inspect dimensions to drawing 0.00
110
 QC Memo 0.00
 Quality Control

Pl 12-03-26 2x

120 Identify as per dwg & Stock Location: WA 0.00
120
 Packaging Memo 0.00
 Packaging

Pl 12-03-26 2x

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 81143***81143***

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March-09-12 1:09:22 PM

Item ID: D4018-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib

Start Date: 09/03/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 16/03/2012 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MLJ 12/03/26

12-03-26

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NOTE: Date & initial all entries

Picklist Print

March-09-12 1:09:26 PM

Page 1

Work Order ID: 81143

81143

Parent Item: D4018-1

D4018-1

Parent Item Name: Rib

Start Date: 09/03/2012

Required Date: 16/03/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg
RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD
10.08.18 verified by:EC IPP Rev:E 11.01.31 chg qc5 to 6 DD
verified by:ec

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304TS0.750W.049 | | Purchased | | | No | 100 | f | 458.0184 | 4.73 | 14.93684 | | | |

M304TS0 750W 049

**

SAD 12-03-28

304 SQ Tube .75x.75x.049W

| Location | Loc Qty | Loc Code |
|----------|-------------|----------|
| MAT018 | 433.2411429 | |
| 117775 | 93.6739 | |
| 118472 | 47.1990839 | |
| 118880 | 0.2736 | |
| 119147 | 76.4906 | |
| 119643 | 39.6981 | |
| 120494 | 175.905859 | |
| MAT034 | 1.8507 | |
| 117337 | 1.8507 | |
| WA035 | 22.92654 | |
| 118184 | 22.92654 | |

120187 → (10)

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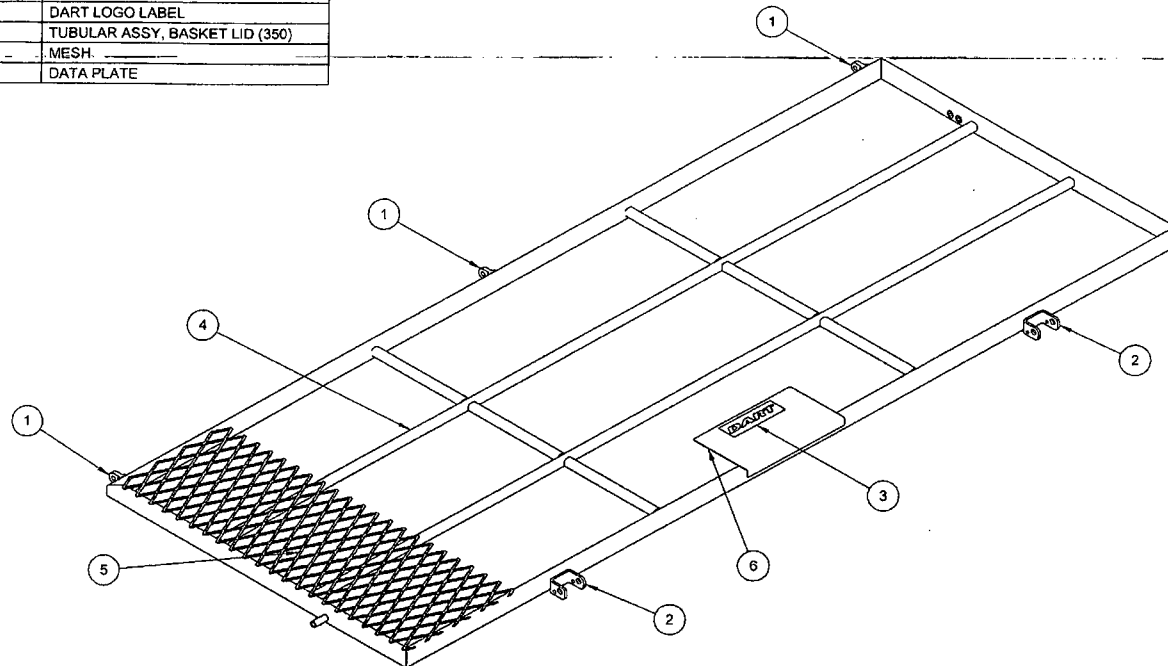
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NOTE: Date & initial all entries

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|-----------|--------------------------------|
| | X | D4018-041 | SHORT BASKET LID ASSY (350) |
| 1 | 3 | D4016-3 | HINGE HALF, LID |
| 2 | 2 | D2581 | MOUNTING BRACKET |
| 3 | 1 | D2728-3 | DART LOGO LABEL |
| 4 | 1 | D4018-101 | TUBULAR ASSY, BASKET LID (350) |
| 5 | 1 | D4020-7 | MESH |
| 6 | 1 | D4021-3 | DATA PLATE |



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81193 MJS
12/03/09

| | | | |
|---|--|---|--------------|
| C | REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A. | MB | 10.08.05 |
| B | BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS REINUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2) & (C82). SIDE VIEWS ADDED (C1-4) & (D1-4). | JPH | 10.03.25 |
| A | NEW ISSUE | JPH | 10.03.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AKS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | DRAWING NO. | REV. C |
| CHECKED | SC | D4018 | SHEET 1 OF 4 |
| MFG. APPR. | AD | TITLE | SCALE |
| APPROVED | AD | SHORT BASKET LID ASSY (350) NTS | |
| DE APPR. | AD | DATE 10.08.05 | |
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RELEASED
10.08.12.09
ECN 10-596

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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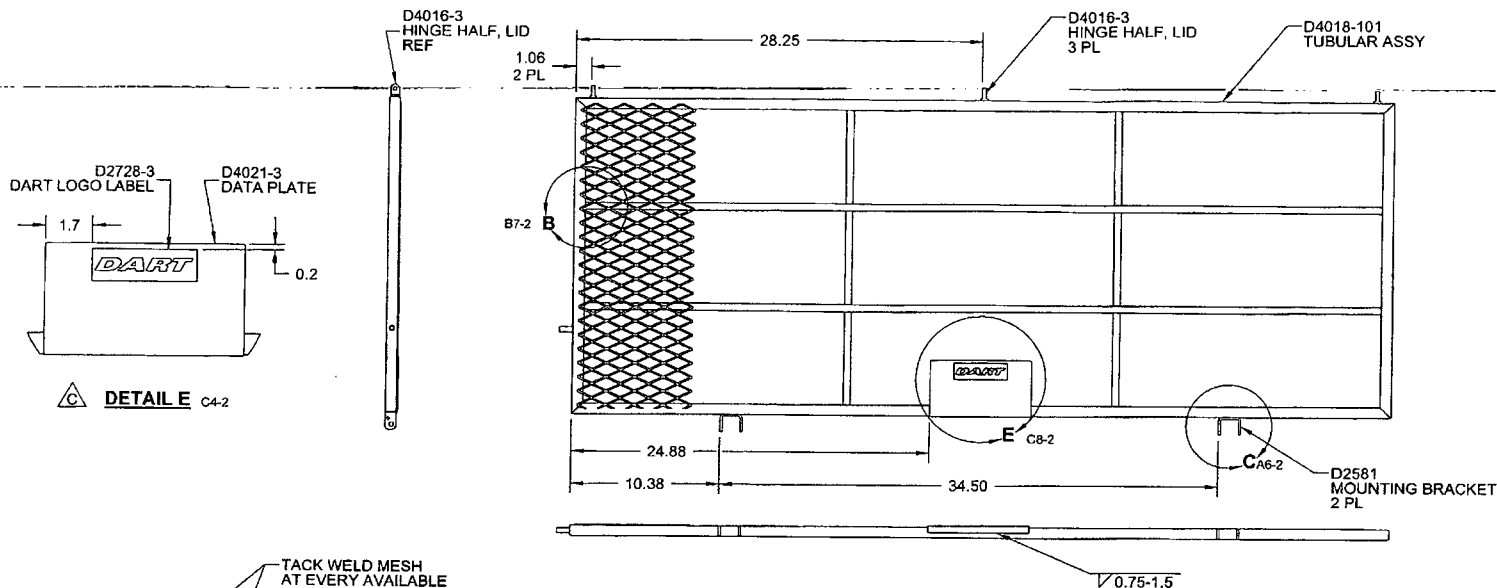
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

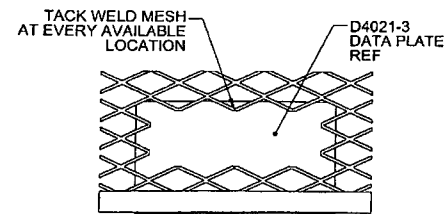
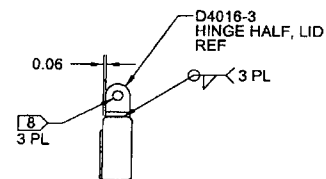
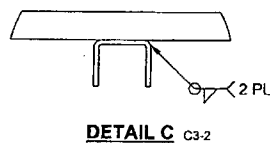
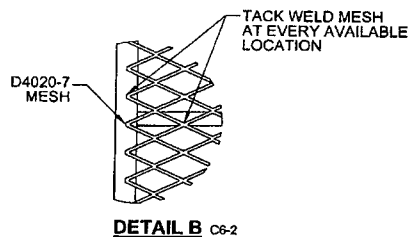
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NOTE: Date & initial all entries

81143



DETAIL E C4-2



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.05

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.5 lbs APPROX
 - 8) MASK HOLES PRIOR TO FINISHING
 - 9) WELD PER DART QSI 004

DETAIL D D1-2

| | | | |
|--|----------|--|--------------|
| DESIGN | ALS | DART AEROSPACE LTD | |
| DRAWN | h | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | SC | DRAWING NO. | REV. C |
| MFG. APPR. | h | D4018 | SHEET 2 OF 4 |
| APPROVED | h | TITLE | SCALE |
| DE APPR. | h | SHORT BASKET LID ASSY (350) NTS | |
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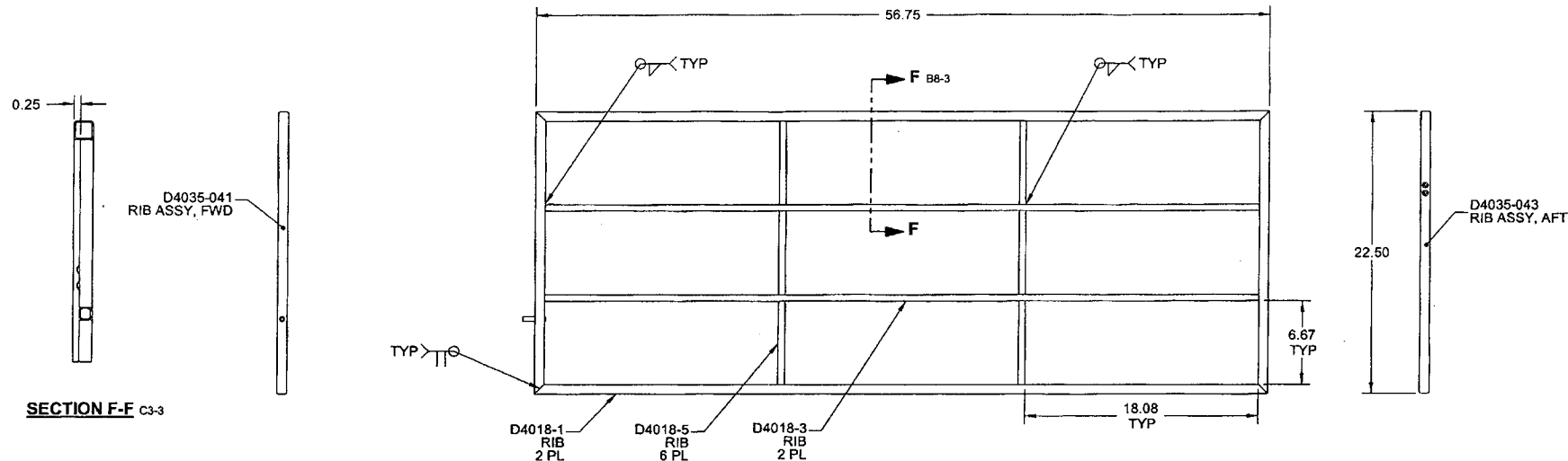
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NOTE: Date & initial all entries

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|-----------|--------------------------------|
| | X | D4018-101 | TUBULAR ASSY, BASKET LID (350) |
| 1 | 2 | D4018-1 | RIB |
| 2 | 2 | D4018-3 | RIB |
| 3 | 6 | D4018-5 | RIB |
| 4 | 1 | D4035-041 | BASKET LID RIB ASSY, FWD |
| 5 | 1 | D4035-043 | BASKET LID RIB ASSY, AFT |

81143



8 D4018-101 TUBULAR ASSY, BASKET LID (350)

RELEASED
10.08.05

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

| | | | |
|------------|----------|--|--------------|
| DESIGN | ALS | DART AEROSPACE LTD | |
| DRAWN | J | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | SC | DRAWING NO. | REV. C |
| MFG. APPR. | DA | D4018 | SHEET 3 OF 4 |
| APPROVED | WMP | TITLE | SCALE |
| DE APPR. | HA | SHORT BASKET LID ASSY (350) | NTS |
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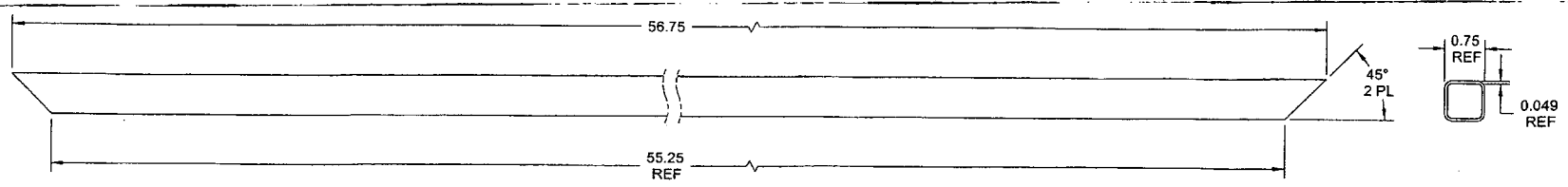
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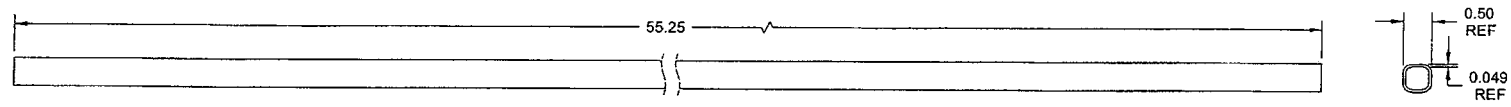
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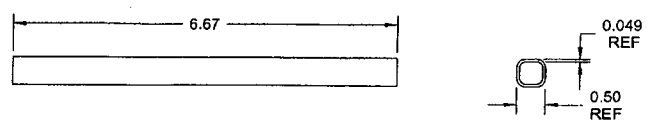
81143



D4018-1 RIB



D4018-3 RIB



D4018-5 RIB

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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10.08.05

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| CHECKED | ISC | DRAWING NO. | REV. C |
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